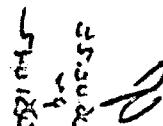


Date: Thursday, 8/24/2006 11:11:44 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 28334
Estimate Number : 10823
P.O. Number : N/A
This Issue : 8/24/2006 **S.O. No.** : N/A
Prsht Rev. : NC
First Issue : N/A **Type** : MACHINED PARTS
Previous Run : 26742
Written By :
Checked & Approved By : *KA 06.08.24*
Comment : Est. D 05.14.02 Removed 303 SS KJ/EC

Drawing Name : SPACER BUSHING

Part Number : D23271
Drawing Number : D2327 REV C
Project Number : N/A
Drawing Revision : C
Material : N/A
Due Date : 8/31/2006 **Qty:** 50 **Um:** Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304R0375	304 SS ROUND BAR
		Comment: Qty.: 0.1860 f(s)/Unit Total : 9.2978 f(s) M18993 (M304TR Ø.375 W65) 3.348 ft Inventory Material: AISI 304 Round Bar Ø0.375" Batch: M100 255 → 5.952 ft <i>SG 06/08/25</i>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		Comment: HARDINGE CNC LATHE SMALL Turn per Folio FA232 and Dwg D2327 Deburr <i>SG 06.08.25</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>SG 06.08.26 BC</i>
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <i>J.G 06/08/28</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST31 <i>SG 06/08/28</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-08-26	2	Mat'l missing to complete w/o. 304ss tubing used instead M304 TR 0.375 w. .065 ID opened up to .257" sum. 250"		BC	06-08-26	18	GP 06-08-26 P~ QSI 042		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				
06-08-26	2								

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/08/01

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Thursday, 8/24/2006 11:11:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 28334

Part Number: D23271

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

 06/09/01

Job Completion



U86-09-01

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	28334
Description: Spacer Bushing	Part Number:	D2327-1
Inspection Dwg: D2327	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	06/08/25	Date:	06/08/25	Date:	

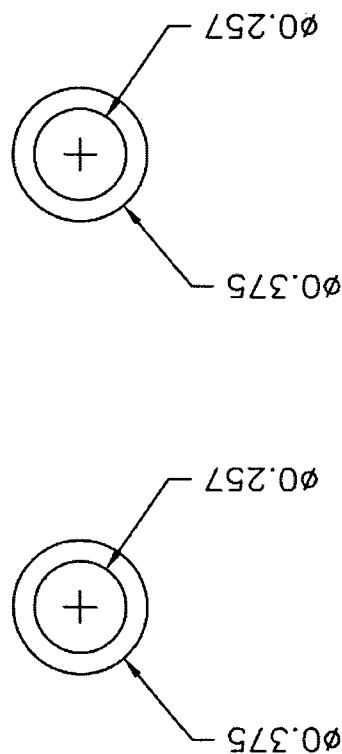
Rev	Date	Change	Revised by	Approved
A	03.11.27	New Issue	KJ/RF	TT

DART AEROSPACE LTD		HAWKESBURY, ONTARIO, CANADA	
DESIGN BY BW	DRAWN BY <i>JL</i>	DRAWING NO. D2327	REV. C SHEET 1 OF 1 SCALE 2:1
CHECKED <i>JL</i>	APPROVED <i>JL</i>		
DATE 03.05.13	TITLE SPACER BUSHING		
A B C	94.12.17 NEW ISSUE 95.12.06 LENGTH CHANGE 03.05.13 303 SS SPEC ADDED		



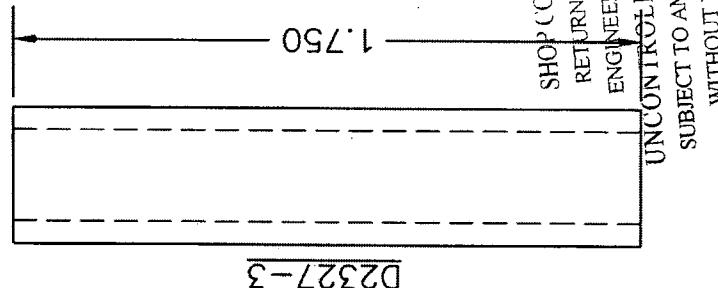
DART

RELEASED
03.05.21-#



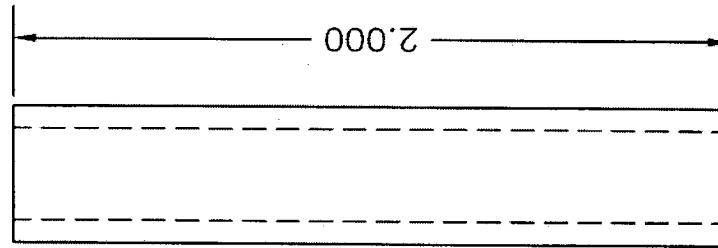
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: NONE
MATERIAL: #0.375 AISI 303 ROUND BAR (REF DART SPEC.)
WALL SEAMLESS ROUND TUBING (REF. DART SPEC.)
M303R0.375) OR #0.375 AISI 304/316 SS 0.065
M304TR0.375W.065)

5) BREAK ALL SHARP EDGES 0.005 TO 0.010
4) ALL DIMENSIONS ARE IN INCHES
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) FINISH: NONE
1) MATERIAL: #0.375 AISI 303 ROUND BAR (REF DART SPEC.)
NOTE: WORK ORDER NO. 324



D2327-3

SHOP COPY
RETURN TO:
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 324



D2327-1